

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-68 Date Opened: 16-Jun-15 Title: FabricationAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Multiple Quantity: 10**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69830	3	Fwd Beam	JR
69831	3	Aft Beam	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

10 EA
N/A
JR
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
JR
JR

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 26-Jun-15

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 26-Jun-15

Work Order closed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 26-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country

Transport Canada

2. AUTHORIZED RELEASE CERTIFICATE
FORM ONE

3. Form Tracking No.

4. Organization Name and Address

AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3

5. Work Order/Contract/Invoice

WO 2015-68

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	N/A	New
2.	Aft Beam	69831-02	1		

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.☐ Non approved design data specified in block 12.14a. ☐ CAR 571.10 Maintenance Release☐ Other regulation specified in block 12~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.~~

13b. Signature

13c. Approved Organization Number

14b. Signature

14c. Approved Organization Number

13d. Name

Jeff Clarke – AD02

13e. Date (dd/mm/yyyy)

30 Dec 2015

14d. Name

14e. Date (dd/mm/yyyy)


Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

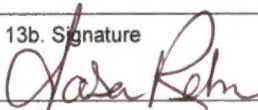
HMC HELICOPTERS

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-68	
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<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 18 Aug 2015		14d. Name		14e. Date (dd/mm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

IMS - HELI SPIRIT

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		AMF 73-04				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
Jason Rekve – AD01		24 Mar 2016				
Installer Responsibilities						
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

ALPINE

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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jason Rekve – AD01		13e. Date (dd/mmm/yyyy) 24 Mar 2016		14d. Name		14e. Date (dd/mmm/yyyy)
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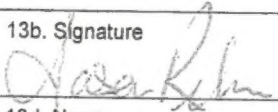
ALPINE

2 SETS.

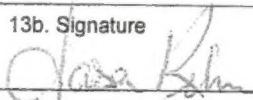


WO# 2015-68

Approved Manufacturing Facility 73-04

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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jason Rekve - AD01		13e. Date (dd/mmm/yyyy) 23 Feb 2016		14d. Name		14e. Date (dd/mmm/yyyy)
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AVIALTA

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4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-68	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
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2	Aft Beam	69831-02	1	N/A	New	
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13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
Jason Rekve - AD01		23 Feb 2016				
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AVAL TA

Aero Design

Parts Distribution Sheet

Avia Ha

Description: Beam Pin

WO# 2016-58 JC 2015-68

[illegible]

CABW STEP PINS



B206L

Description: ~~STEP STOP FIN~~ X. BEAMS

WO# 2015-68

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 69831-02

Aircraft: Bell

Model: 206L/407

Description: AFT Beam

Supplier: Aero Design

Color: White

WO#: 2015-68

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69831-02

Aircraft:

Bell

Model: 206L/407

Description:

AFT Beam

Supplier:

Aero Design

Color:

White

WO#:

2015-68

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 69830-02

Aircraft: Bell

Model: 206L/407


Description: Forward Beam

Supplier: Aero Design

Color: White

WO#: 2015-68

PO# N/A

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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 26 June 2015		14d. Name		14e. Date (dd/mm/yyyy)
Installer Responsibilities						
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Description: Beam Pin

WO# _____

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 69830-02

Aircraft: Bell

Model: 206L/407

Description: Forward Beam

Supplier: Aero Design

Color: White

WO#: 2015-68

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69831-02

Aircraft:

Bell

Model: 206L/407

Description:

AFT Beam

Supplier:

Aero Design

Color:

White

WO#:

2015-68


PO# N/A

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-68	
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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 06 Apr 2016		14d. Name		14e. Date (dd/mmm/yyyy)
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TAIGA



06 APR 2016

WO# 2015-68

[illegible]

06 APR 2016



Description: Beam Pin

WO# 2015-68

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0056
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-68
6. Item 1 2	7. Description Forward Beam Aft Beam	8. Part Number 69830-02 69831-02	9. Qty. 1 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 12 May 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
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CANADIAN HELICOPTERS



WO# 2015-68

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 03 Mar 2016		14d. Name		14e. Date (dd/mmm/yyyy)
Installer Responsibilities						
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Grafton HZL

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69830-02

Aircraft:

Bell

Model: 206L/407

Description:

Forward Beam

Supplier:

Aero Design

Color:

White

WO#:

2015-68

PO# N/A



Description: Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

MOUNTING BEAM FABRICATION – 69830/69831

General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision 3 – Forward Beam

69831, Revision 3 – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

Work Order: 2015-68

Batch Quantity: 10 sets

Complete
(initial or SCA #)

Date Open: 16-Jun-15

1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02 ADD

- a. Cut 1 x 2 x 0.12 material as indicated on drawings.
 - i. 69830-02: 69830-13 (long tube), 69830-14 (down tube)
 - ii. 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder.
- d. Remove writing on tubes with acetone.
- e. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 69830-02 / 69831-02 ADD

- a. Run CNC programs to machine keyways, slots and holes in component parts.
- b. De-burr keyways, slots and holes.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components – 69830-02 / 69831-02 ADD

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- a. Shear and bend caps: 69830-19, 69830-20, 69831-20.
- b. Cut and turn 69830-15 bushings and 69830-11 guide tubes:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - iv. Setup stop and face other end to length @ 1000 RPM.
 - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- c. Cut 69830-07 blocks.
- d. Record component POs / WOs on attached material list.

4. Beam Welding – 69830-02 / 69831-02

- a. TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- c. Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- d. Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- e. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing.
 - ii. 69830-07 stops over bottom outboard keyway and top inboard keyway.
 - iii. 69830-19, 69830-20, 69831-20 caps.
- f. Record component and welding rod POs / WOs on attached material list.
- g. Tag in-progress parts for finishing.

5. Beam Finishing – 69830-02 / 69831-02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - ii. Use a block to distribute press loads, about 2" wide
 - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane using hydraulic press.
 - i. Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - ii. Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - iii. Pressurize ram to 800 psi to hold beam.
 - iv. Clamp a snipe tube to down tube.
 - v. Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - vi. Check beams for plane, repeat steps ii-v if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts for inspection.

6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

- a. Inspect beams 69830-02 and 69831-02 for conformity to drawing.
- b. Tag in-progress parts ready for powder coating.

7. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.

8. Final Assembly

To be completed after powder coating.

- a. Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- b. Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- c. Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.
- d. Adhere P/N placard to top surface of beam, between strap and end on top surface.
- e. Green tag completed beam assemblies and place into stock.



WO# 205-68

[illegible]

Work Order: 2015-68Material Tracking Sheet
Bell 206L / 407 Aft Mounting Beams

1 of 2

Date Open: 16-JUN-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
	10		69831-02	Aft Beam Assembly		
Step 1				Fabrication		
	. 1		69831-13	Tube	304 Stainless, 1x2x0.125 tube	14060/15024
	. 1		69831-14	Tube	304 Stainless, 1x2x0.125 tube	14060
	. 1		69831-15	Tube	304 Stainless, 1x2x0.125 tube	14060/15024
Step 2				Machining	None	
Step 3				Fabrication		
	. 2		69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	15024
	. 1		69830-16	Strap	304 Stainless, 0.105" Sheet	13083
	. 1		69830-17	Block	304 Stainless, 3/16" x 3/4" bar	2014-49/13028
	. 1		69830-19	Cap	321 Stainless, 0.032" Sheet	3021
	. 1		69830-20	Cap	321 Stainless, 0.032" Sheet	3021
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	2015-14
Step 4				Welding		
	. A/R		--	Welding Rod	ER308L	14028
Step 5				Straightening	None	
Step 6				Inspection	None	
Step 7				Powder Coating		
Step 8				Final Assembly		
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		

Work Order: 2015-68Material Tracking Sheet
Bell 206L / 407 Aft Mounting Beams

2 of 2

Date Open: 16-JUN-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8.c.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	

Work Order: 2015-68Date Opened: 16-Jun-15Material Tracking Sheet
Bell 206L/407 Forward Mounting Beams

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	10		69830-02	Forward Beam Assembly		
Step 1				Fabrication		
	1		69830-13	Tube	304 Stainless, 1x2x0.125 tube	14060/15024
	1		69830-14	Tube	304 Stainless, 1x2x0.125 tube	14060/15024
Step 2				Machining	None	
Step 3				Fabrication		
	2		69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	2015-68 & 15024
	1		69830-16	Strap	304 Stainless, 0.105" Sheet	13023
	1		69830-17	Block	304 Stainless, 3/16" x 3/4" bar	2014-49 / 13028
	1		69830-19	Cap	321 Stainless, 0.032" Sheet	3021
	1		69830-20	Cap	321 Stainless, 0.032" Sheet	3021
	1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	2015-14
Step 4				Welding		
	A/R		--	Welding Rod	ER308L	14028
Step 5				Straightening	None	
Step 6				Inspection	None	
Step 7				Powder Coating		
Step 8				Final Assembly		
Step 8.a.	1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
	1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	1		69830-23	Spring	15mm x 70 mm Spring	
	1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	1		MS21044C3	Nut		

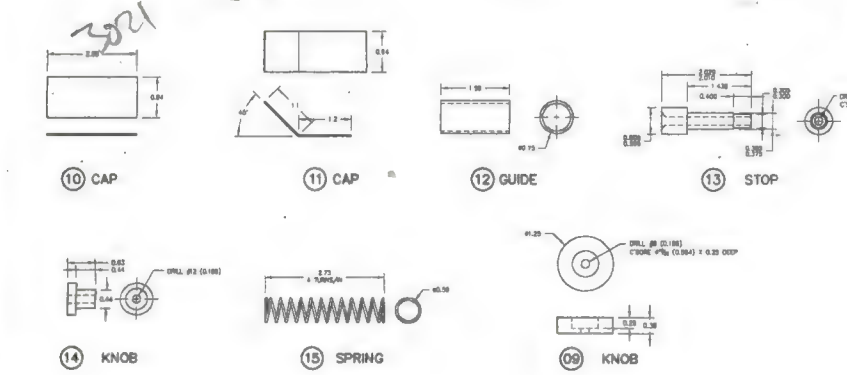
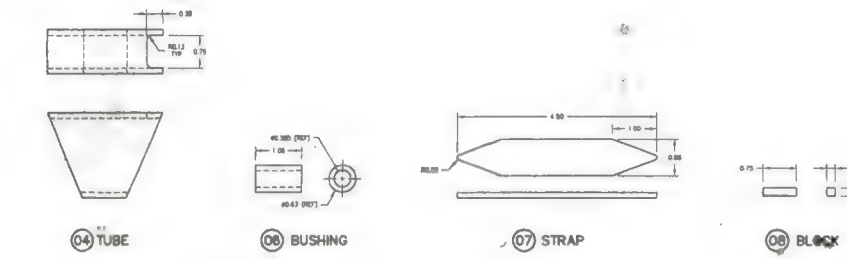
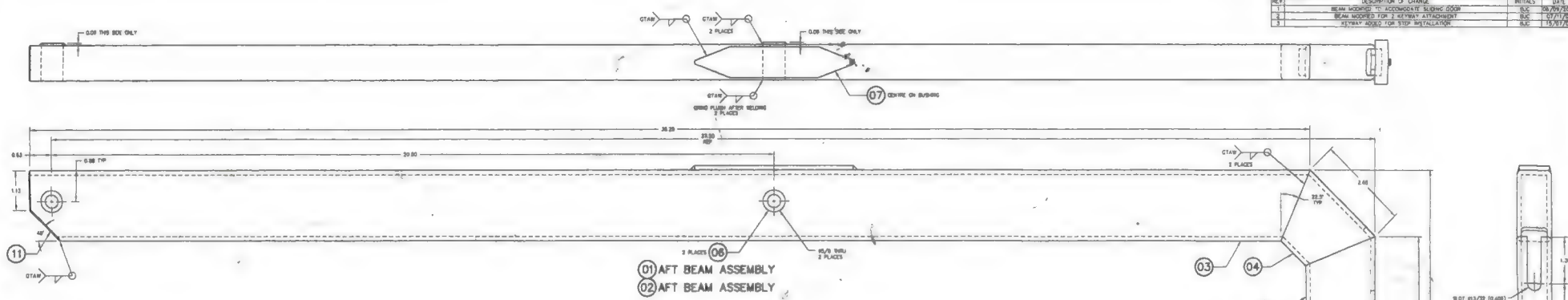
Work Order: 2015-68Material Tracking Sheet
Bell 206L/407 Forward Mounting Beams

2 of 2

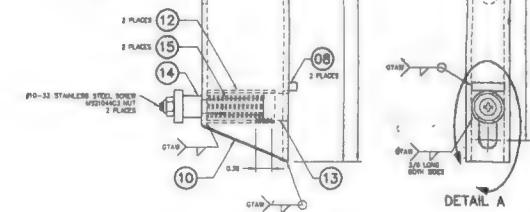
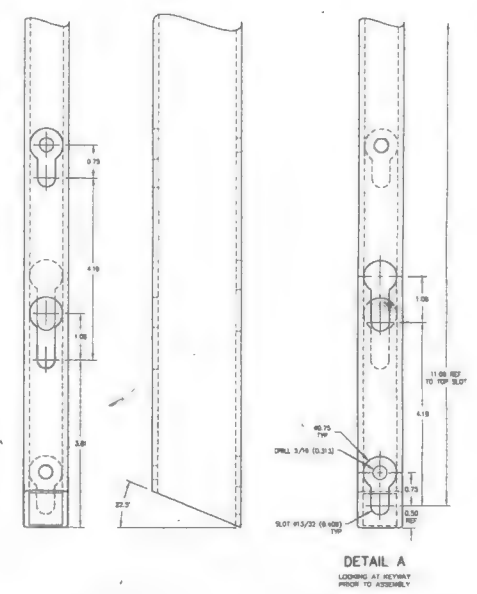
Date Opened: 16-JUN-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	BEAM MODIFIED TO ACCOMMODATE SLIDING DOOR	SAC	08/09/2000
2	BEAM MODIFIED FOR 2 KEYWAY ATTACHMENT	WCC	07/17/00
3	KEYWAY ADDED FOR STOP INSTALLATION	SAC	10/07/00



- NOTES
- REMOVE ALL BURRS AND BREAK SHARP EDGES
 - WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D8.0. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT FOR 4130/4140 STEEL. WELDING ROD SHALL CONFORM TO ER308 OR EQUIVALENT FOR STAINLESS STEEL.
 - ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND UNIFORM COATED PRIOR TO ASSEMBLY
 - AFT BEAM ASSEMBLY (09031-01) MAY BE USED AS A DIRECT REPLACEMENT FOR AFT BEAM ASSEMBLY (09031-01).



QTY	PART NO.	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	09031-01	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-02	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-03	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-04	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-05	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-06	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-07	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-08	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-09	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"
1	09031-10	AFT BEAM ASSEMBLY (STAINLESS STEEL)	304 STAINLESS STEEL	1/2" X 3/4" X 12"	1/2" X 3/4" X 12"

APPROVALS

DATE

08 APR 2000

DESIGNED BY

E. BLOOM

CHECKED BY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DIMENSIONS ARE: X.XX ±0.010 X.XX ±0.003 X.XX ±0.001

SCALE: 1" = 1"

SHEET 1 OF 1

AO 69831 3

AERO DESIGN LTD.

CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 0000

3003 - 30TH AVENUE S.W. CALGARY, ALBERTA, CANADA, T2C 1P7

TEL: (403) 243-8887 FAX: (403) 243-8888

BELL 206L / 407

QUICK RELEASE CARGO BASKET

AFT BEAM FABRICATION

41.18

01 FORWARD BEAM ASSEMBLY
02 FORWARD BEAM ASSEMBLY

15024

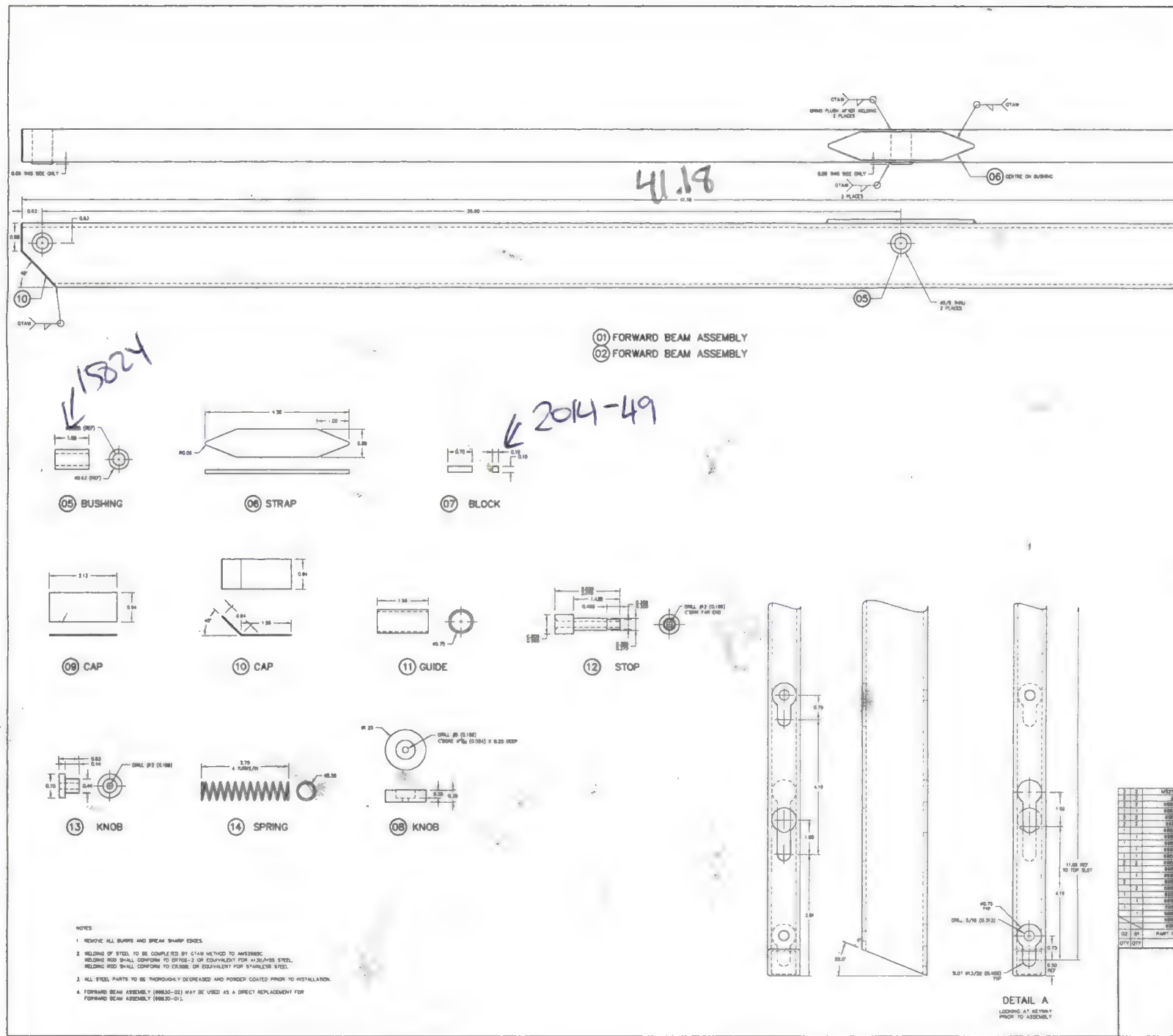
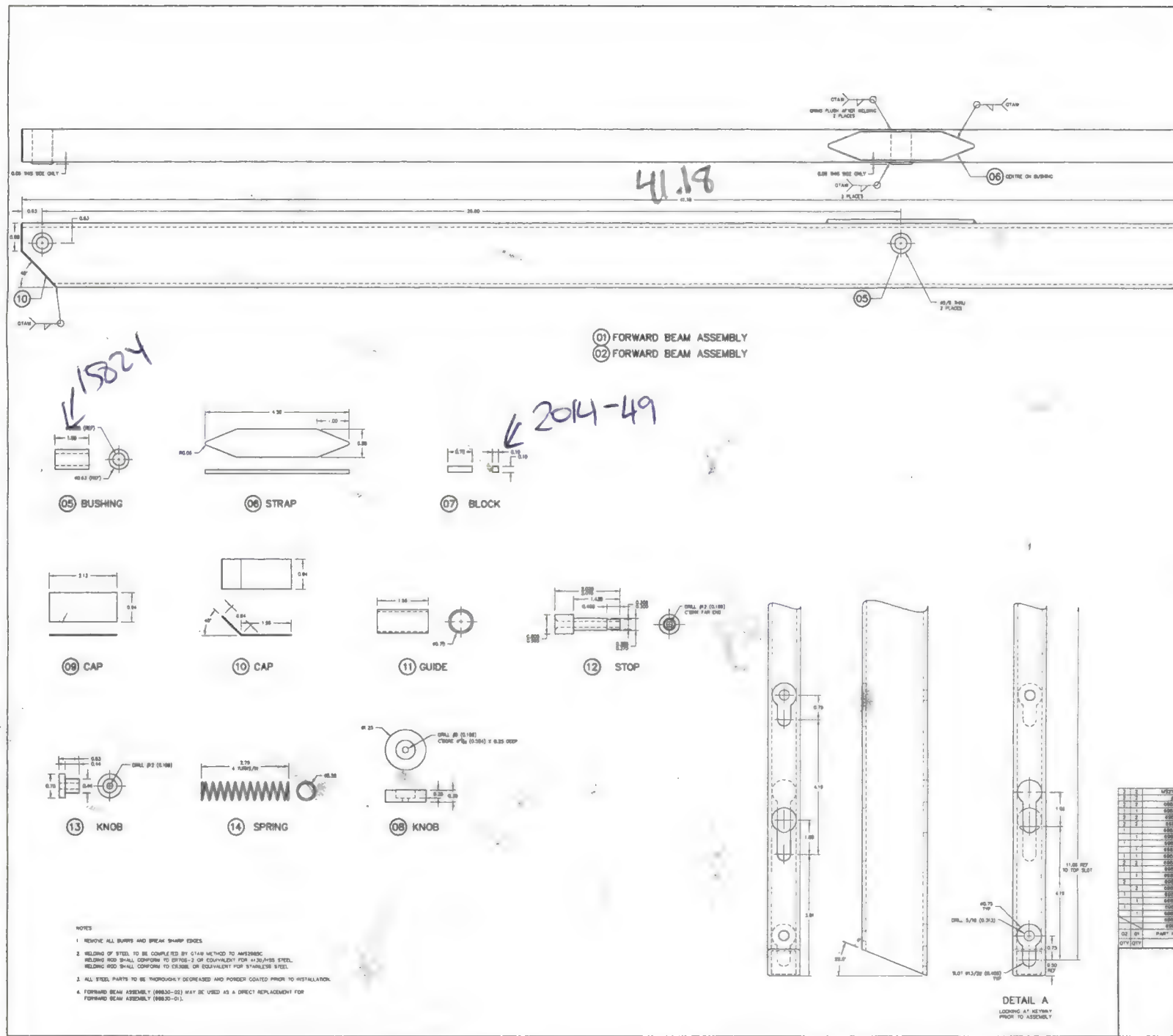
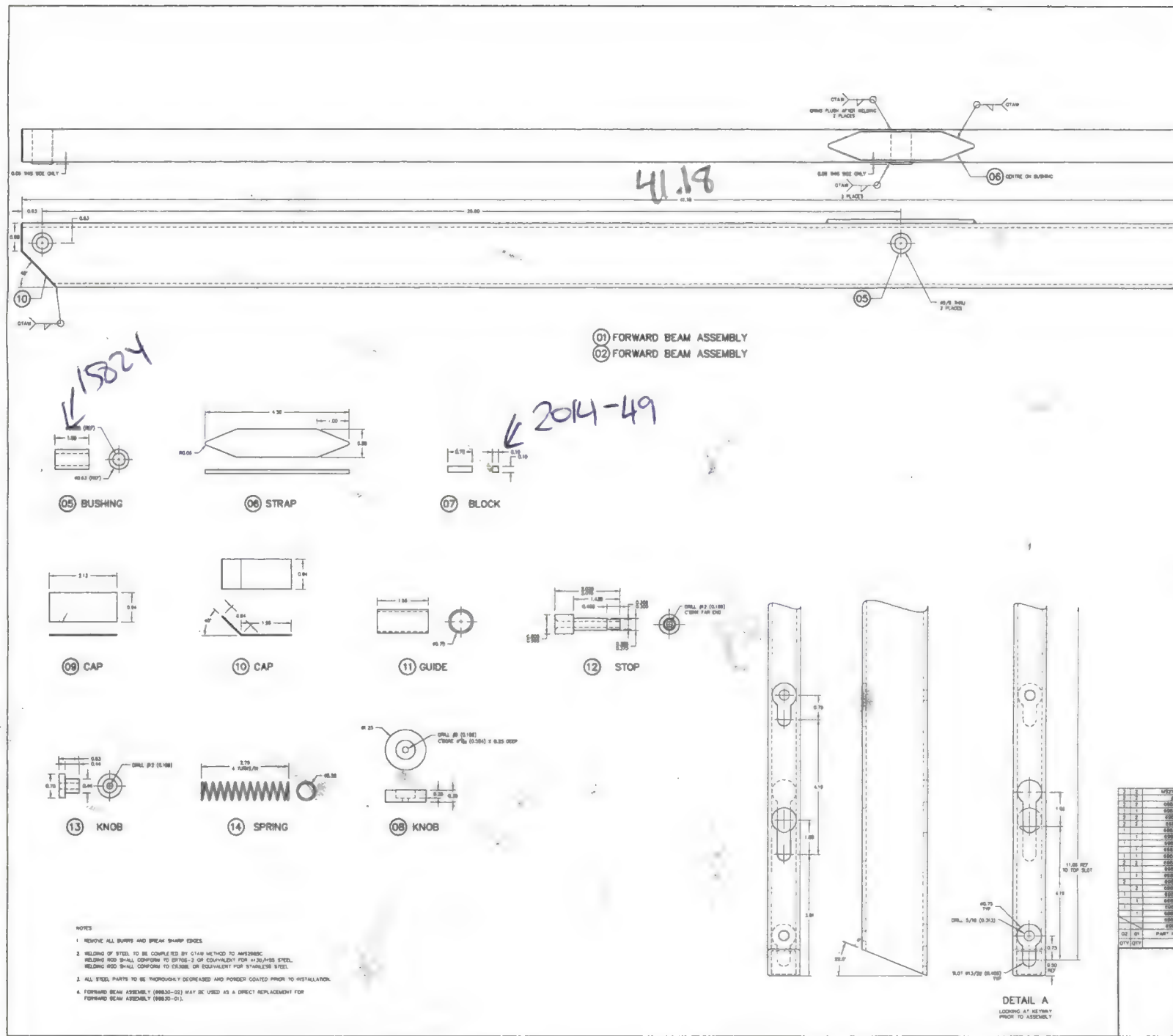
2014-49

05 BUSHING
06 STRAP
07 BLOCK
09 CAP
10 CAP
11 GUIDE
12 STOP
13 KNOB
14 SPRING
08 KNOB

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY G148 METHOD TO AMERICAN WELDING ROD SHALL CONFORM TO STS-2 OR EQUIVALENT FOR A304/316 STEEL. WELDING ROD SHALL CONFORM TO EX-306 OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.
4. FORWARD BEAM ASSEMBLY (00030-02) MAY BE USED AS A DIRECT REPLACEMENT FOR FORWARD BEAM ASSEMBLY (00030-01).

DETAIL A
LOOKING AT KEYWAY
PRIOR TO ASSEMBLY

[illegible]



Description: B206L BEAMS

WO# 2015-6.f

[illegible]

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-69 Date Opened: 16-Jun-15 Title: FabricationAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Beams Product Model: N/A Quantity: 10/1081
12 kg
D JC**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Insti

10/10
N/A
N/A
JR

8/12 JC

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
78633	1	Aft Beam	JR
78634	1	Fwd Beam	JR

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: J Rekve for M Rekve

Sign:

ICC / Dual Inspection preformed by:

Print: Jason Rekve

Sign:

Work Order closed by:

Print: Jason Rekve

Sign:

SCA: AD01

Date: 22-Oct-15

SCA: AD01

Date: 22-Oct-15

SCA: AD01

Date: 22-Oct-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

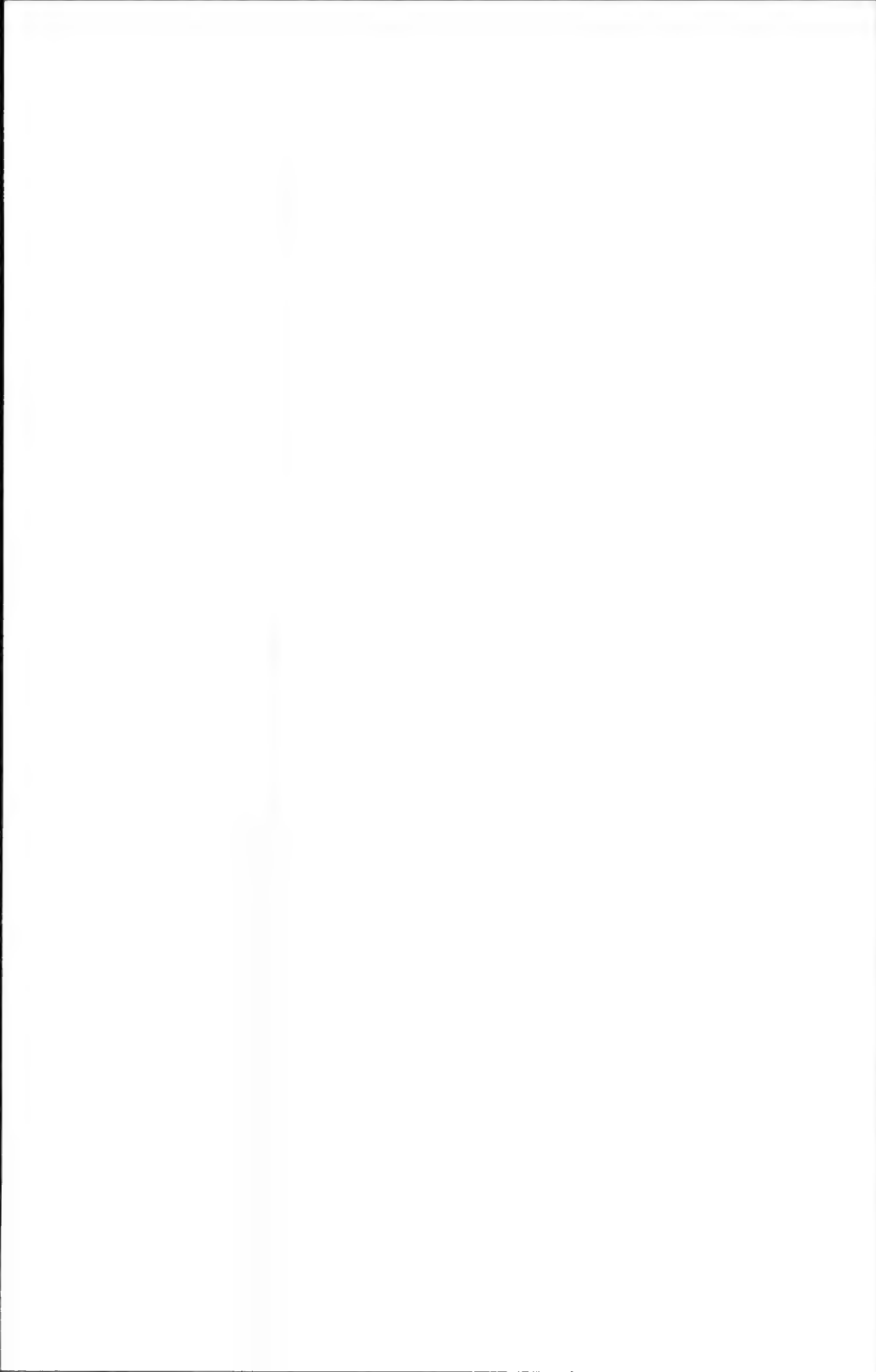
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-69
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Forward Beam	78634-01-00	1	N/A	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 30 Oct 2015		14c. Approved Organization Number	
14d. Name		14e. Date (dd/mmm/yyyy)		14f. Signature	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					


Selfick Mountain



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 30 Oct 2015		14d. Name		14e. Date (dd/mmm/yyyy)
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Selfick Mountain



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-69
6. Item	7. Description Forward Beam	8. Part Number 78634-01-00	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 30 Oct 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	

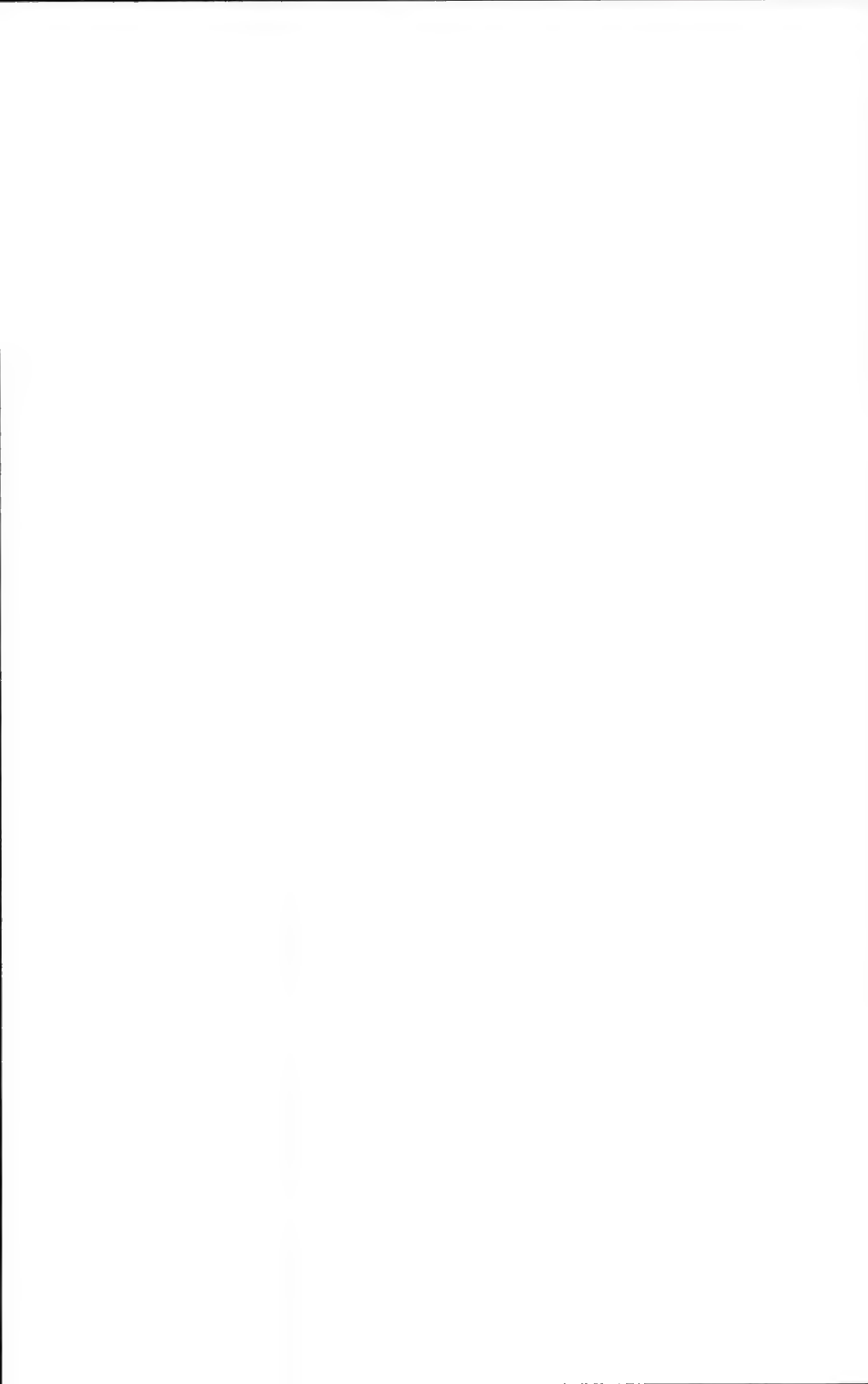
Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Self Kirk Mountain



1. Approving Civil Aviation Authority/Country Transport Canada	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3. Form Tracking No.
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4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	5. Work Order/Contract/Invoice WO 2015-69
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6. Item	7. Description Forward Beam	8. Part Number 78634-01-00	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
---------	---------------------------------------	--------------------------------------	---------------------	------------------------------------	-------------------------------

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.	14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.
---	---

13b. Signature <i>Jeff Clarke AD02</i>	13c. Approved Organization Number AMF 73-04	14b. Signature	14c. Approved Organization Number
13d. Name Jeff Clarke – AD02	13e. Date (dd/mmm/yyyy) 30 Oct 2015	14d. Name	14e. Date (dd/mmm/yyyy)

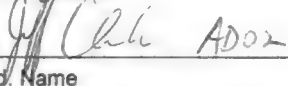
Installer Responsibilities	
This certificate does not constitute authority to install.	
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.	
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.	

Belkirk Maintain



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	LH Aft Beam	78633-01-02	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 22 Oct 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

BAILEY

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 17 Dec 2015		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

SELKIRK MOUNTAIN



WO# 2015-69

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013




WO# 2015-69

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-69
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	LH Aft Beam	78633-01-02	1	N/A	New
2.	Forward Beam	78634-01-00	1		
12. Remarks Black					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations .		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 02 Feb 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

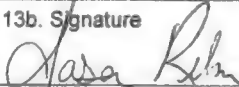
KOOTENAY VALLEY HELI

WO#

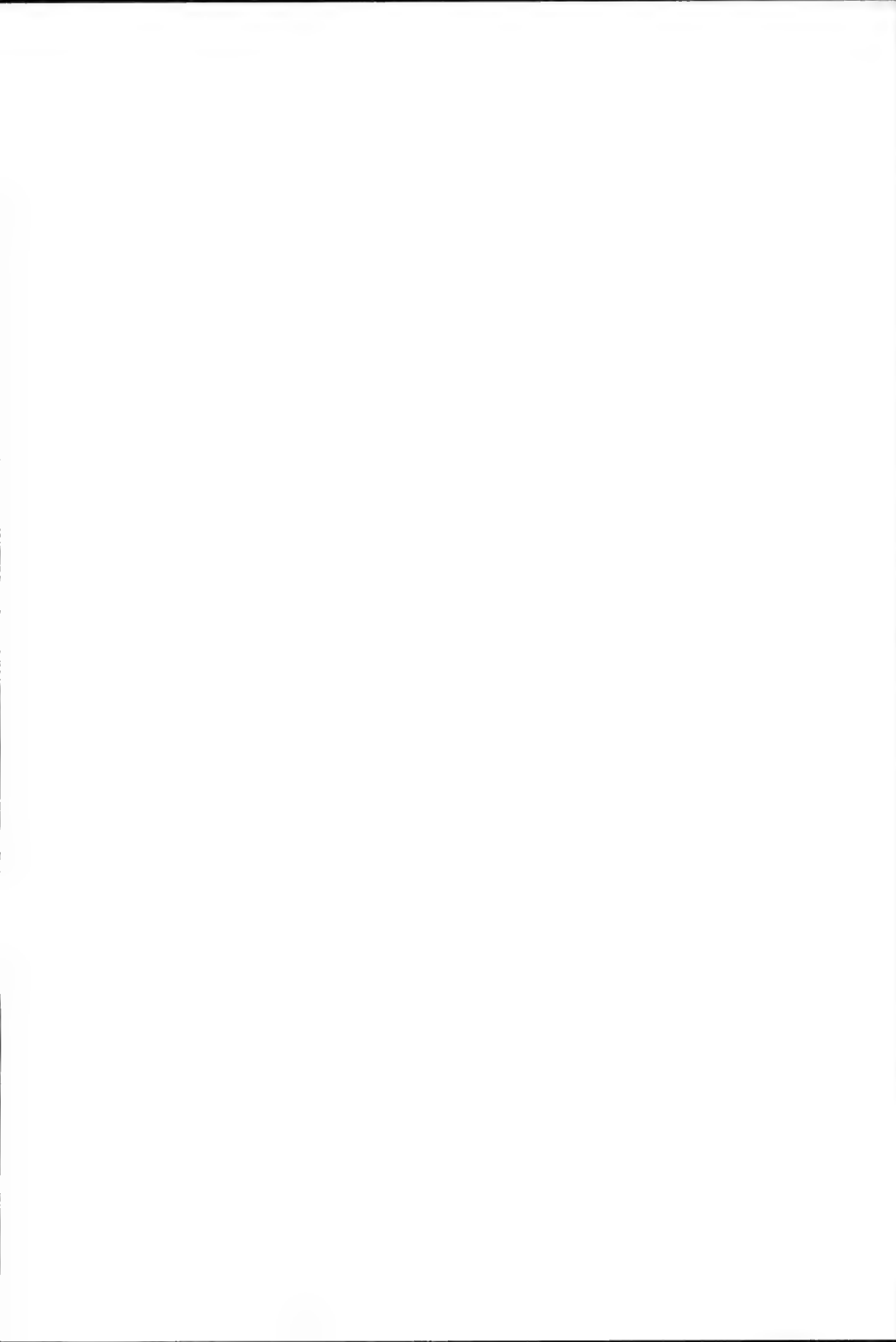
Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

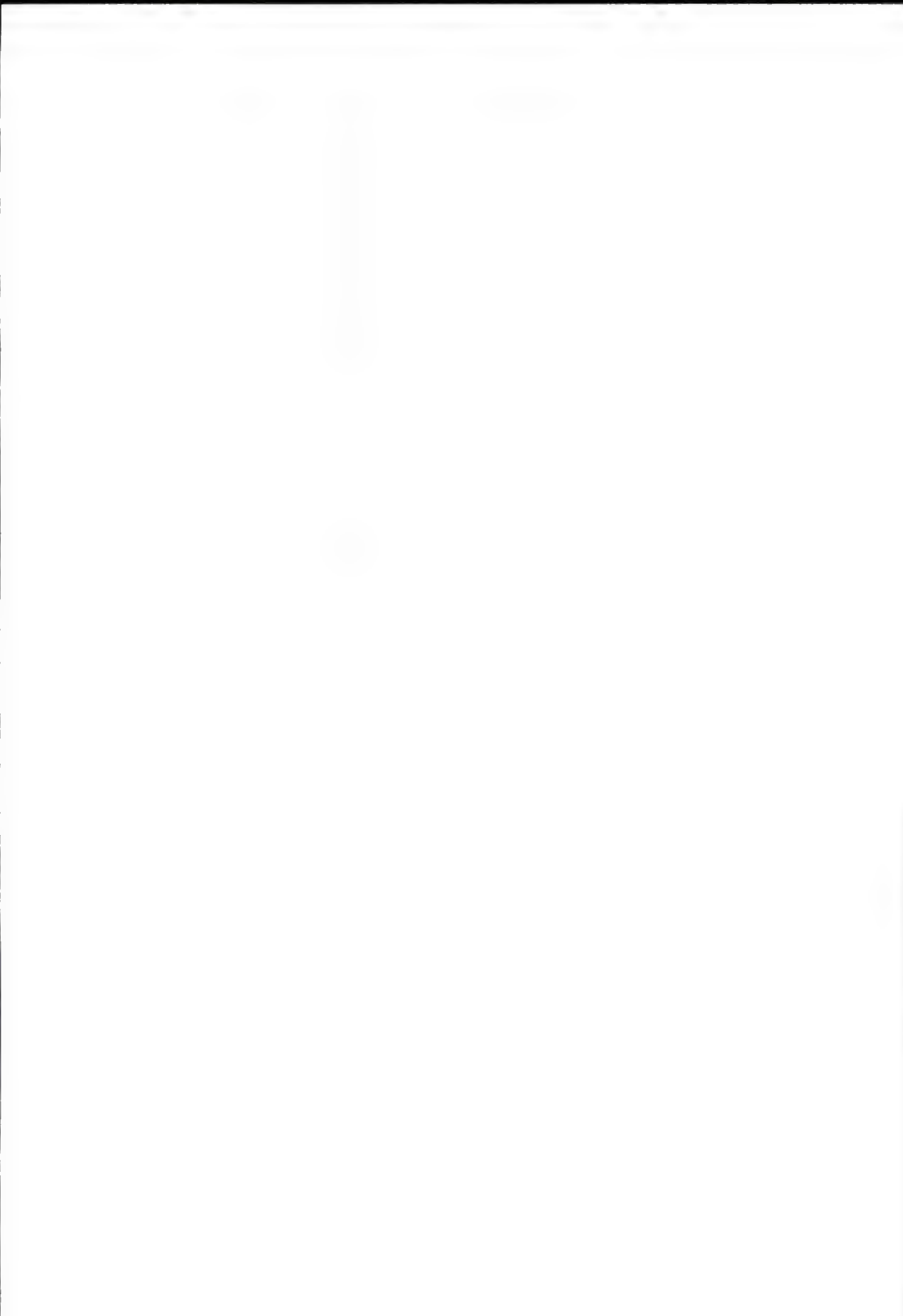
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam	78633-01-02	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jason Rekve - AD01		13e. Date (dd/mm/yyyy) 24 Aug 2015		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						


AIRSPAN



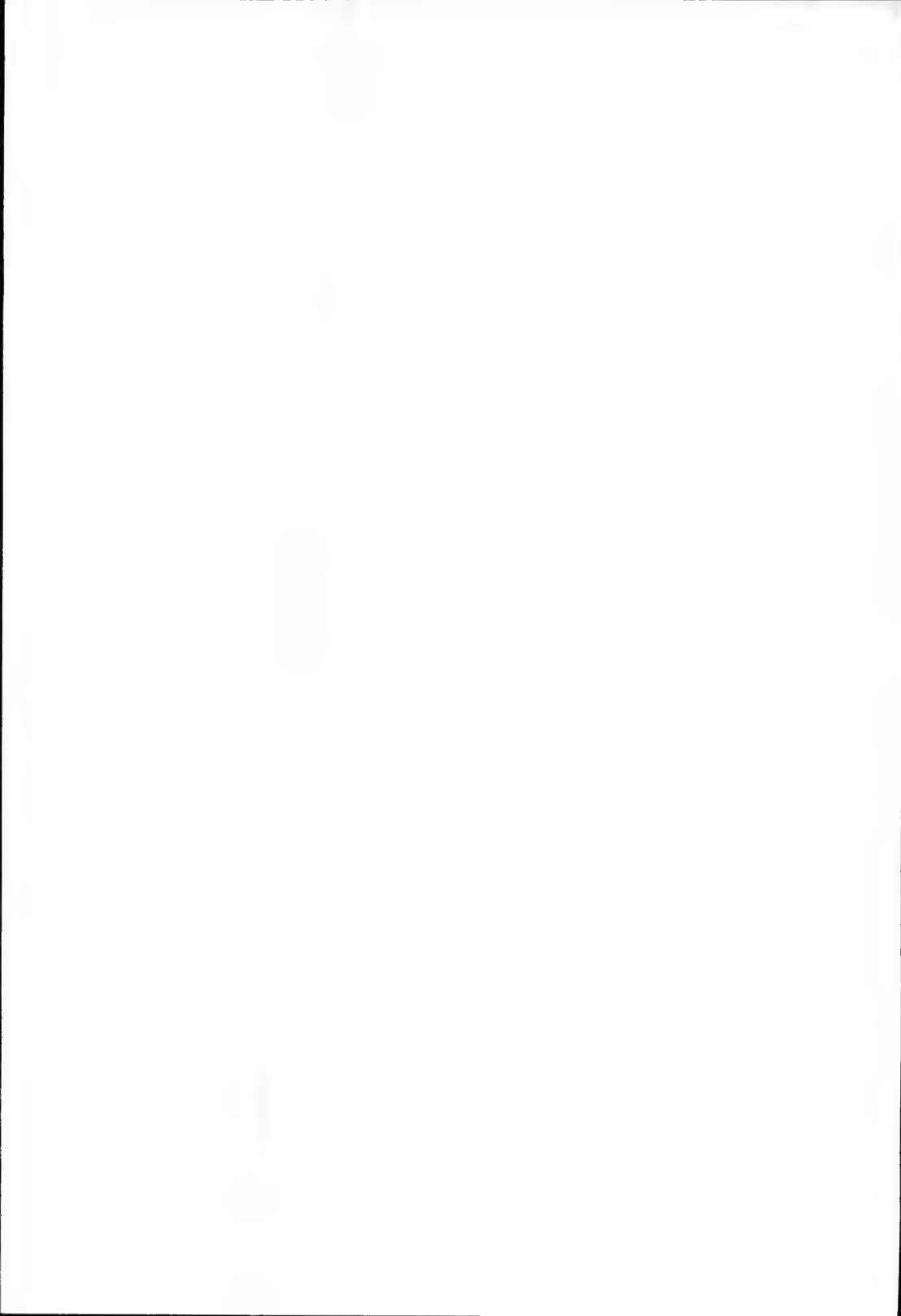
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam	78633-01-02	1	N/A	New	
2.	Forward Beam	78634-01-00	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				<div style="border: 1px solid black; padding: 5px;"> 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. </div>		
13b. Signature 		13c. Approved Organization Number AMF 73-04		<div style="border: 1px solid black; height: 40px; position: relative;"> <div style="position: absolute; top: 0; right: 0; width: 100%; height: 100%; background: linear-gradient(to top right, transparent 49%, black 49%, black 51%, transparent 51%); background-size: 40px 40px;"></div> </div>		
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 05 Jan 2016		<div style="border: 1px solid black; height: 40px; position: relative;"> <div style="position: absolute; top: 0; right: 0; width: 100%; height: 100%; background: linear-gradient(to top right, transparent 49%, black 49%, black 51%, transparent 51%); background-size: 40px 40px;"></div> </div>		
Installer Responsibilities						
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						


F12THAWK



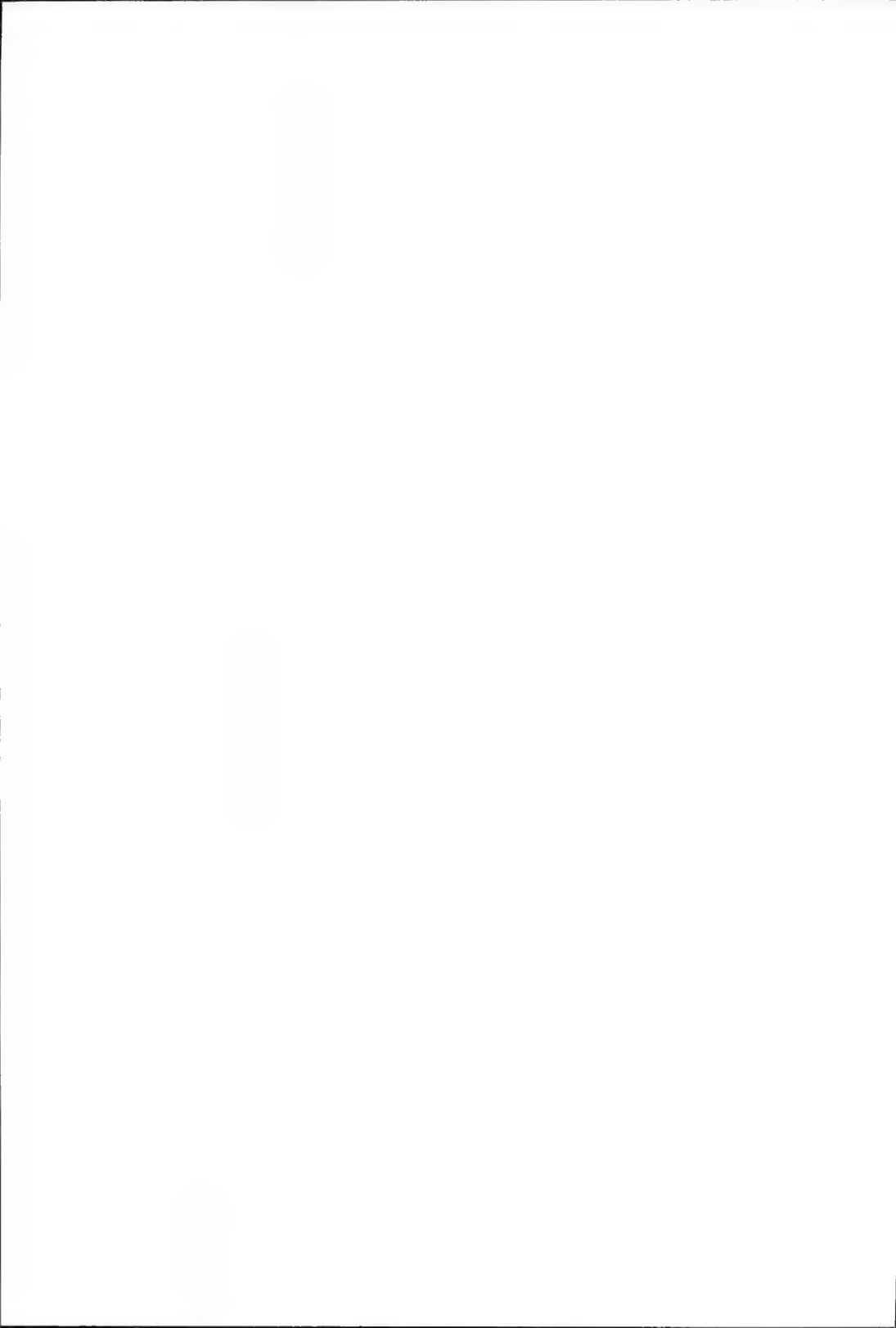
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam	78633-01-02	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 13 Jan 2016		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						


FIREHAWK



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam	78633-01-02	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 13 Jan 2016		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						


File Hawk



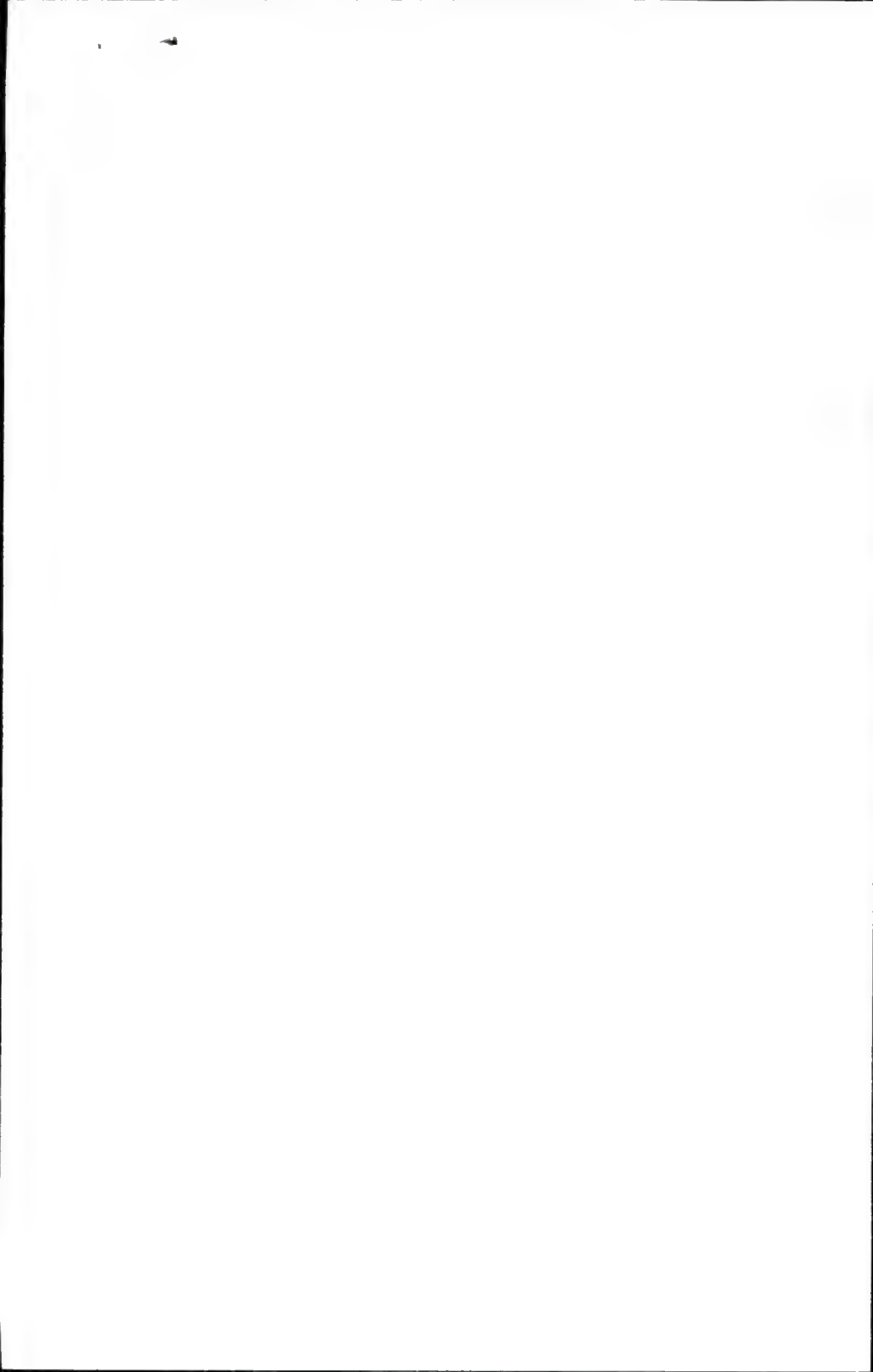
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam Ass'y	78633-01-02	1			
2.	Forward Beam Ass'y	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 07 Jan 2016		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

JAB/BS HCU



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-69	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	LH Aft Beam	78633-01-02	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 18 Jan 2016		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

WHITE RIVER



W/ S/N 94001-55



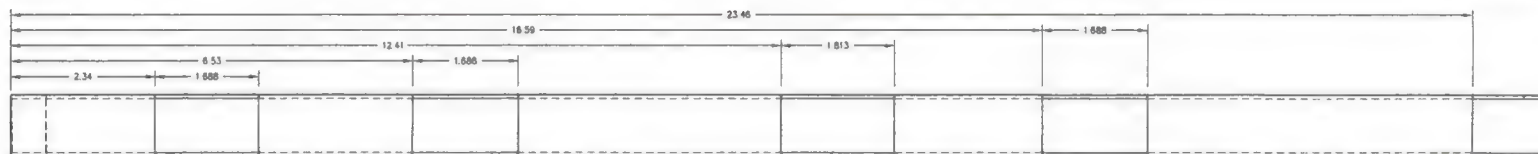
Description: AS350 Ski Basket

WO# 2015-69

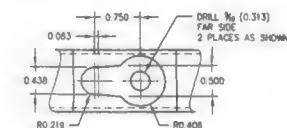
From PO or WO #	Quantity	Description	Part Number	For WO #
2013-11	1	RH AFT BEAM	78633-01-01	
2015-65	1	LH AFT BEAM	78633-01-02	
2015-69	1	FWD BEAM	78634-01-00	
2015-109	1	PIN	69830-21	
2015-109	1	KNOB	69830-22	
13227	1	SCREW	#10-32 x 3.0 C'SUNK	
15071	1	SPRING	69830-23	
13048	1	NUT	MS21044C3	
11091	+ 2	GRIP TAPE		
2014-23	1	SITOR STEP	82715-01	
2014-23	1	BRACKET	82733-01	
2014-23	1	BUSHING	82733-02	
15051	2	AN BOLT	AN4-42A	N/A
15014	4	WASHER	NAS1149F0463P	
14073	2	NUT	MS21044N4	
15022	2	BOLT	AN3-35A	
15031	4	WASHER	NAS1149F0303P	
15031	2	NUT	MS21044N3	
15066	2	GRIP TAPE	3M SAFETY WALK	

2015-69

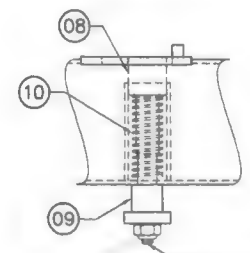
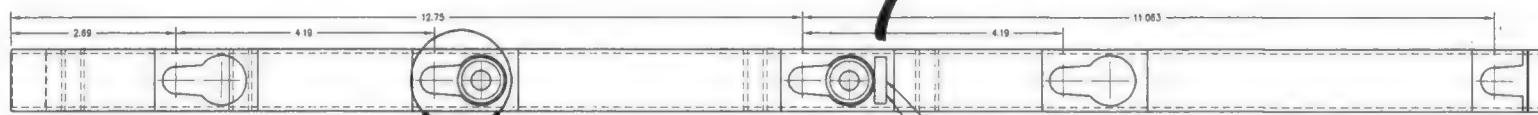
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 78632	BJC	APR 01/10
1	TITLE BLOCK UPDATED, PADS (ITEM 11, 12) ADDED, ALTERNATE FINISH	BJC	14/07/2014
	CAP (ITEM 04) MATERIAL CHANGED, SLOT DEPTH INCREASED		



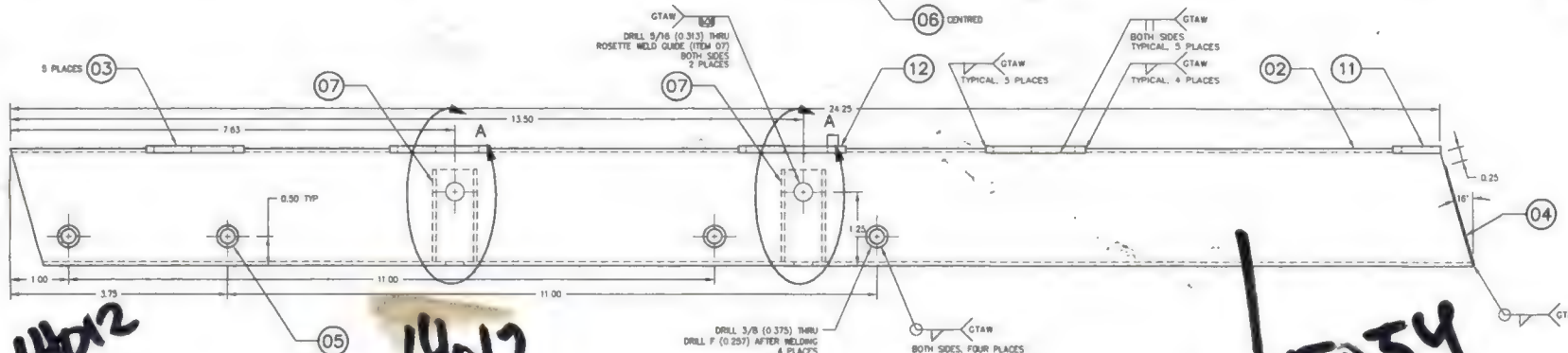
TOP VIEW PRIOR TO WELDING



DETAIL B
TYPICAL ALL KEYWAYS



DETAIL A
ASSEMBLY AFTER FINISHING



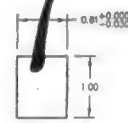
01 78634-01-00 BEAM ASSEMBLY

14012

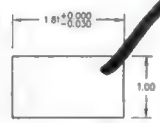
14012

PO 15054

14012



11 PAD



12 PAD



04 CAP



05 BUSHING



03 PAD

NOTES

- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES
- 2 WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
- 3 FINISH: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY ALTERNATE: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED, PRIMED AND PAINTED PRIOR TO ASSEMBLY

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	78634-12	12	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-11	11	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
2	MS21044C3		NUT	304 STAINLESS STEEL	COMMERCIAL	
2	1/16-32	10	SPRING	STAINLESS STEEL	COMMERCIAL	13mm X 70mm SPRING
2	69830-22	09	KNOB	6061-T6 ALUMINUM	00-A-200/R	40.75 ROD
2	69830-21	08	STOP	6061-T6 ALUMINUM	00-A-200/R	40.625 ROD
2	69830-11	07	GUIDE	304 STAINLESS STEEL	ASTM A289	40.75 X 0.065 RND TUBE
1	69830-07	06	BLOCK	304 STAINLESS STEEL	ASTM A479	0.186 SQR ROD
4	78634-04	05	BUSHING	304 STAINLESS STEEL	ASTM A289	40.375 X 0.065 RND TUBE
1	78634-04	04	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
3	78634-03	03	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.063 TUBE
1	78634-01-00	01	BEAM ASSEMBLY			

APPROVALS	DATE	
DESIGN: JEFF CLARKE	01 APR 2010	
CHECKED: E BURGOIN		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		
DECIMALS	ANGLES	
X.XXX ±0.010	±1/2°	
X.XX ±0.03		
X.X ±0.1		
SCALE 1:1	DWG SIZE	DWG NO
SHEET 1 OF 1	A1	78634
		1



AERO DESIGN LTD.

0808A MALASPINA ROAD
POWELL ROVER, BC, CANADA, V8A 0G3
TEL: 604 480.8276
www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
ATTACHMENT PROVISION
FORWARD BEAM FABRICATION

21. 2. 1945

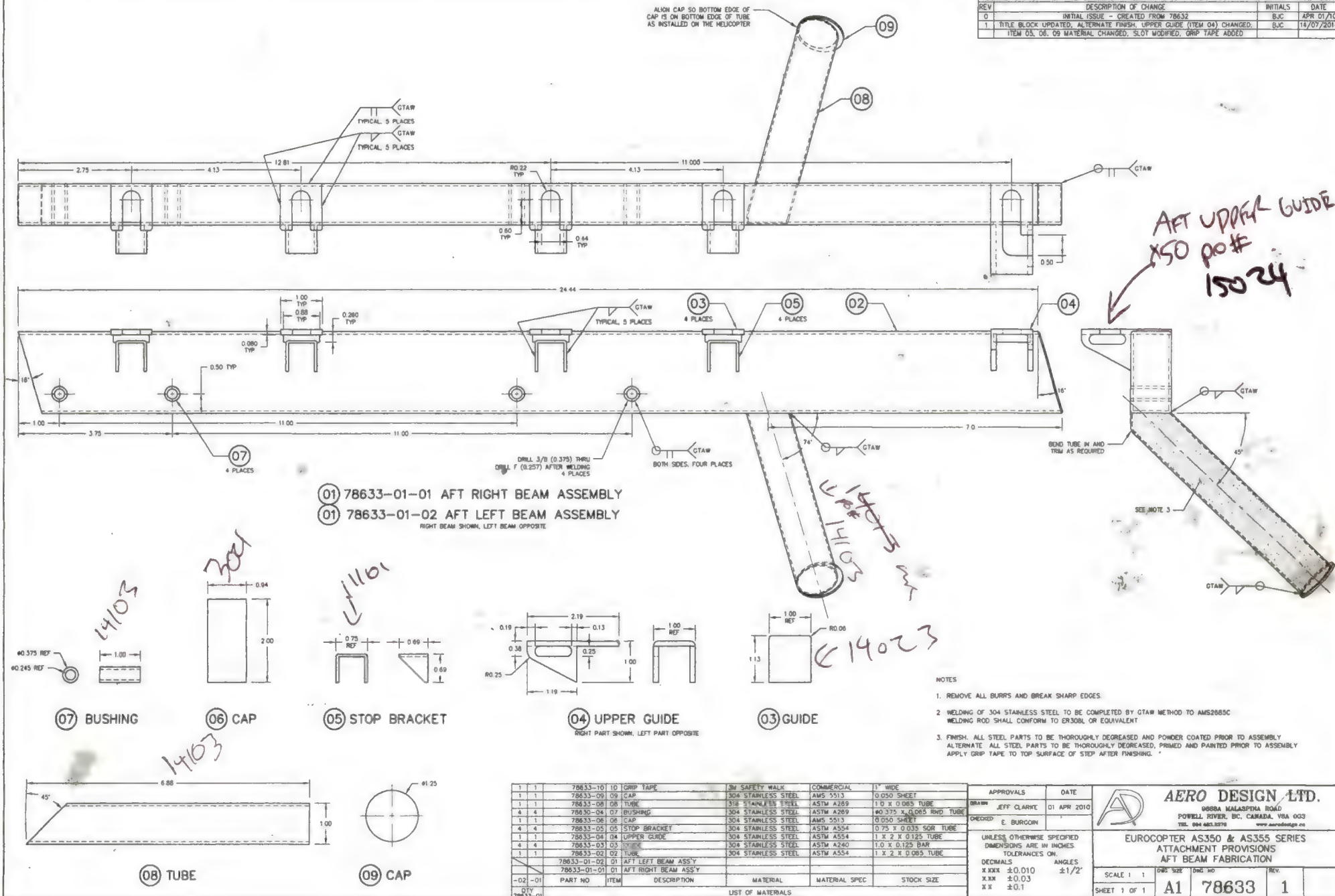
21. 2. 1945

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THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OR ANY PORTION THEREOF MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REVIEW, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 78632	BJC	APR 01/10
1	TITLE BLOCK UPDATED, ALTERNATE FINISH, UPPER GUIDE (ITEM 04) CHANGED.	BJC	14/07/2014
	ITEM 03, 06, 09 MATERIAL CHANGED, SLOT MODIFIED, GRIP TAPE ADDED		



Wm

MOUNTING BEAM FABRICATION – 78633/78634

General

These instructions apply to mounting beams 78633-01 (aft) and 78634-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633, Revision 1 – Aft Beam

78634, Revision 1 – Forward Beam

Work Order: 2015-69

Batch Quantity: 10 8 AFT LIT
12 FWD

Complete
(initial or SCA #)

Date Open: 16-Jun-15

1. Beam Fabrication – 1x2 tubes – 78633-01 / 78634-01

AP06

- Cut 1 x 2 x 0.065 material as indicated on drawings.
 - 78633-02 – 24.44"
 - 78634-02 – 24.25"
- Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 78633-01 / 78634-01

AP02 Aft
AP02 Fwd

- Run CNC programs to machine slots and holes in 78633-02 tubes and 78634-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components – 78633-01

AP06

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78633-06
- Cut 78633-03 guides from 1x1/8 stock.
- Cut and turn 78630-04 bushings from 3/8 x 0.065 tube:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 78633-04 upper guides from blanks machined in step 2.b.
- Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
- Cut 82735-03 step tubes from 1.0 x 0.035 tube.
- Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.

- h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

4. Beam Fabrication – Components – 78634-01

AD-06

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- a. Shear caps from 0.025" sheet: 78634-04.
- b. Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- c. Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - iv. Setup stop and face other end to length @ 1000 RPM.
 - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- d. Cut 69830-07 blocks.
- e. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

5. Beam Welding – 78633-01

AD-05

- a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
 - i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts for straightening.

6. Beam Welding – 78634-01

AD-05

- a. TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
 - i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

7. Beam Straightening – 78633-01 / 78634-01

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- a. Set beam on blocks as far apart as possible on hydraulic press.
- b. Use a 2" block to distribute press loads.
- c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- d. Check for straight with a straight edge on back of tube.
- e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

8. CNC Machining – 78633-01 / 78634-01

- a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening. AD-02 117
- b. Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening. AD-02 Fwd.
- c. De-burr keyways and slots.
- d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

9. Beam Welding – 78633-01

- a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
- b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
- c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
- d. TIG weld 78633-06 cap to 78633-02 tube.
- e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
- f. Record component and welding rod POs / WOs on attached material list.
- g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening. AD-05

10. Beam Welding – 78634-01

- a. TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- c. TIG weld 69830-11 block to 78634-02 tube over 3rd keyway (see drawing) using ER308L rod.
- d. TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- e. Record component and welding rod POs / WOs on attached material list.
- f. Tag in-progress parts and place on in-progress shelf in welding shop for straightening. AD-05

11. Beam Finishing – 78633-01 / 78634-01

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- b. Use a 2" block to distribute press loads.
- c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- d. Check for straight with a straight edge on back of tube.
- e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- f. Drill out bushings to F (0.257"), four places per beam, on drill press.
- g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.



12. Final Inspection – 78633-01 / 78634-01

To be completed by a different person than the previous steps.

- a. Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- b. Tag in-progress parts ready for powder coating.



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.



14. Final Assembly – 78633-01

To be completed after powder coating.

- a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
- b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
- c. Adhere P/N placard to back surface of beam.
- d. Ensure AN4 bolt can be inserted through bushings.
- e. Green tag complete beam assembly and place into stock.



15. Final Assembly – 78634-01

To be completed after powder coating.

- a. Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- b. For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- c. For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- d. If maintenance step is to be installed: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- e. Adhere P/N placard to back surface of beam.
- f. Green tag complete beam assembly and place into stock.

Work Order: 2015-69Material Tracking Sheet
Eurocopter AS350/AS355 Forward Mounting Beam

1 of 2

Date Opened: 16-Jun-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	12		78634-01-00	Forward Beam Assembly		
Step 1				Fabrication		
	1		78634-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	14023
Step 2				Machning	None	
Step 4				Fabrication		
	3		78634-03	Pad	1x0.125 Bar, 304 Stainless Steel	14023
	1		78634-11	Pad	1x0.125 Bar, 304 Stainless Steel	14023
	1		78634-12	Pad	1x0.125 Bar, 304 Stainless Steel	14023
	1		78634-04	Cap	0.025" Sheet, 321 Stainless Steel	.040 nr 3021
	4		78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel	14103
	2	69830	69830-11	Guide	0.75 x 0.065 Tube, 304 Stainless Steel	69830-11 nr 2014-51 / 2015-14
Step 6				Welding		
	A/R		--	Welding Rod	ER308L	14028
Step 7				Straightening	None	
Step 8				Machning	None	
Step 10				Welding		
	A/R		--	Welding Rod	ER308L	14028
Step 11				Finishing	None	
Step 12				Final Inspection	None	
Step 13				Powder Coating		



Work Order: _____

Material Tracking Sheet
Eurocopter AS350/AS355 Forward Mounting Beam

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 15				<i>Final Assembly</i>		
	. 2	69830	69830-21	Stop	0.625 Rod, 6061-T6 Aluminum	
	. 2	69830	69830-22	Knob	0.75 Rod, 6061-T6 Aluminum	
	. 2	69830	69830-23	Spring	15mm x 70mm Spring, Stainless Steel	
	. 2		69830-1032X3	3" #10-32 C'sunk screw	Stainless Steel	
	. 2		MS21044C3	Nut		
	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	

Work Order:

2015-69

Date Opened:

16-Jun-15

Material Tracking Sheet
Eurocopter AS350/AS355 Aft Mounting Beam

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	8		78633-01-02	Aft Beam Assembly	(XX = -01 RH, -02 LH)	
Step 1				Fabrication		
	. 1		78633-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	14623
	. 1		78633-04	Upper Guide	1x2x0.12 Tube, 304 Stainless Steel	15029
Step 2				Machning	None	
Step 3				Fabrication		
	. 4		78633-03	Guide	1x0.125 Bar, 304 Stainless Steel	14023
	. 4		78633-05	Stop Bracket	0.75x0.065 Sqr. Tube, 304 Stainless	10128
	. 1		78633-06	Cap	0.025" Sheet, 321 Stainless Steel	3021
	. 4		78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel	13028
	. 1		82735-03	Tube	1.0 x 0.035 Tube, 316 Stainless Steel	Heavy 1403
	. 1		82735-06	Cap	0.050 Sheet, 321 Stainless Steel	3021
Step 5				Welding		
	. A/R			Welding Rod	ER308L	14005
Step 7				Straightening	None	
Step 8				Machning	None	
Step 9				Welding		
	. A/R			Welding Rod	ER308L	14005
Step 11				Finishing	None	
Step 12				Final Inspection	None	
Step 13				Powder Coating		
		Detail				

Work Order: _____

Material Tracking Sheet
Eurocopter AS350/AS355 Aft Mounting Beam

2 of 2

Date Opened: _____

Ass'y Step	Qty	Drawing	Part Number	Description	Material	PO/WO
Step 14				<i>Final Assembly</i>		
	. 1		--	Grip Tape	1" 3M Safety Walk	
	. 1		--	P/N Placard	TZ tape, 1/2", white on black	

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-70 Date Opened: 19-Jun-15 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket Product Model: XL Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
JR
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket	JR
94011	1	Body	JR
94012	1	Lid	JR
94027	1	Data Card	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: Jason RekveSign: SCA: AD01Date: 19-Jun-15

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 19-Jun-15

Work Order closed by:

Print: Jason RekveSign: SCA: AD01Date: 19-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

2015-70 19-Jun-15

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket
94510, Revision 0 – Extra-Wide Low Mounted Basket
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket
76410, Revision 3 – Medium Basket (left or right)
78410, Revision 2 – Long Basket
94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket
80310, Revision 0 – Medium Basket
81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-70

Date Open: 19 Jun 15

OK

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

OK

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ?? . Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)



6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

Work Order: 2015-70Date Opened: 19-Jan-15

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/VO
			94010-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		<i>2015-62</i>
	. 1		94012-01	Basket Lid Assembly		
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		<i>15031</i>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>14074</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15031</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		<i>2015-62</i>
Step 2.a.	. 1		94011-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		AN960-616	Washer		
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<i>14091</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>15032</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>15031</i>
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2015-02</i>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
Step 4.b.	.. 1		84261-01	Handle Assembly		
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		2015-63
	. 1		AN3-15A	Bolt		14084
	. 1		AN3-17A	Bolt		14084
	. 2		AN970-3	Washer		14084
	. 3		NAS1149F0363P	Washer		15014
	. 2		MS21044N3	Nut		14072
Step 6				<i>Inspection</i>	None	

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-70
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94010-01	1	94001-47	New
12. Remarks Modified with walkway on lid IAW DCL704; Red					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 19 June 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

GUARDIAN



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All Model: N/A

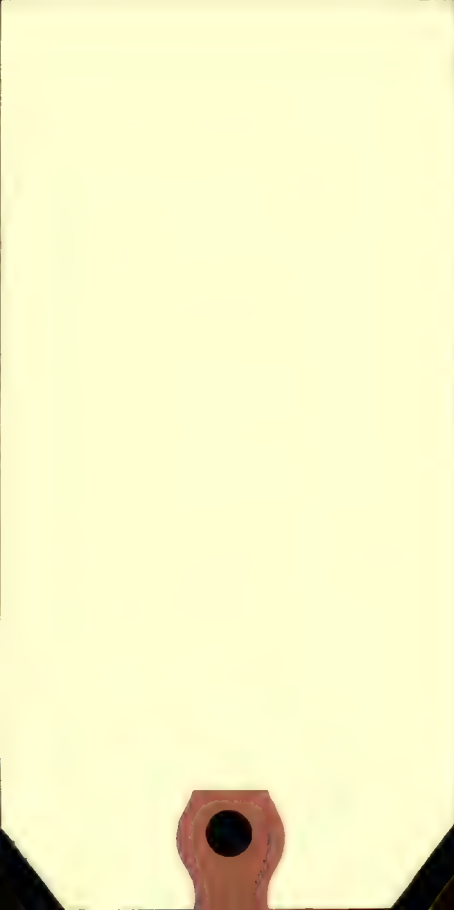
Description: Lid Walkway Checker Plate

Supplier: Daigle Marine

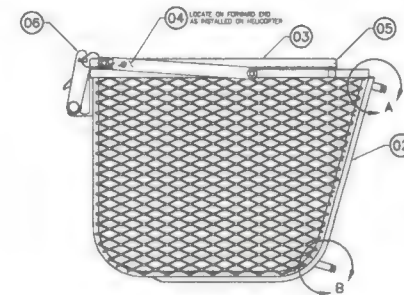
Color: Aluminum

WO#: N/A

PO# 14074



REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	NO. 1 SOURCE		
1	UPDATE TITLE BLOCK, ADD ALTERNATE INVERSE HANDWRING P/MS UPDATED CHANGE BRACE APPROPRIATE TO INSTALLATION	BUC	8/8/73




DETAIL B
SCALE 1/2" = 1'-0"
TYPICAL FRONT AND REAR

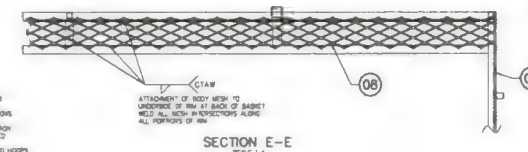
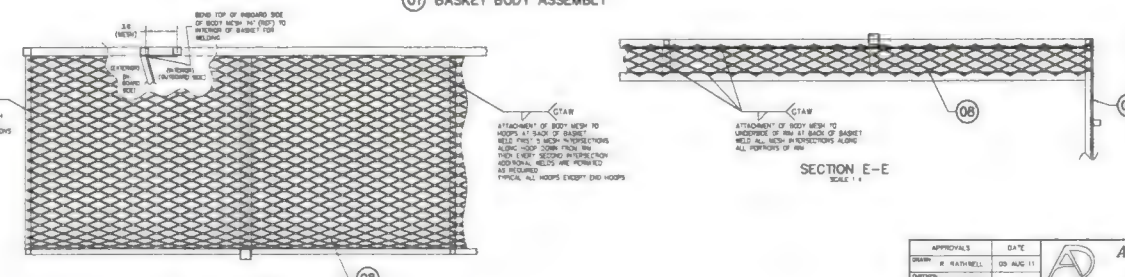
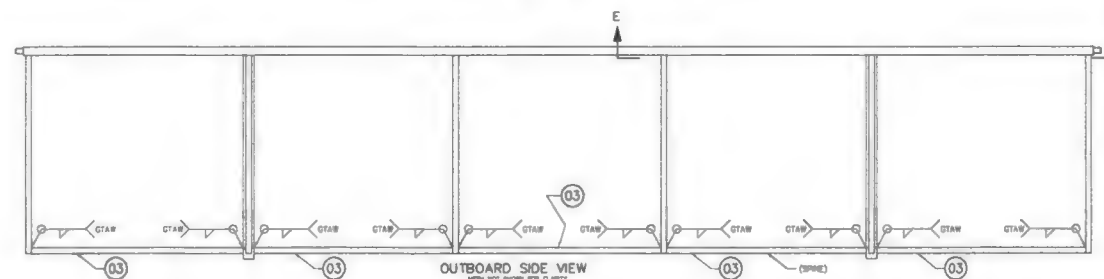
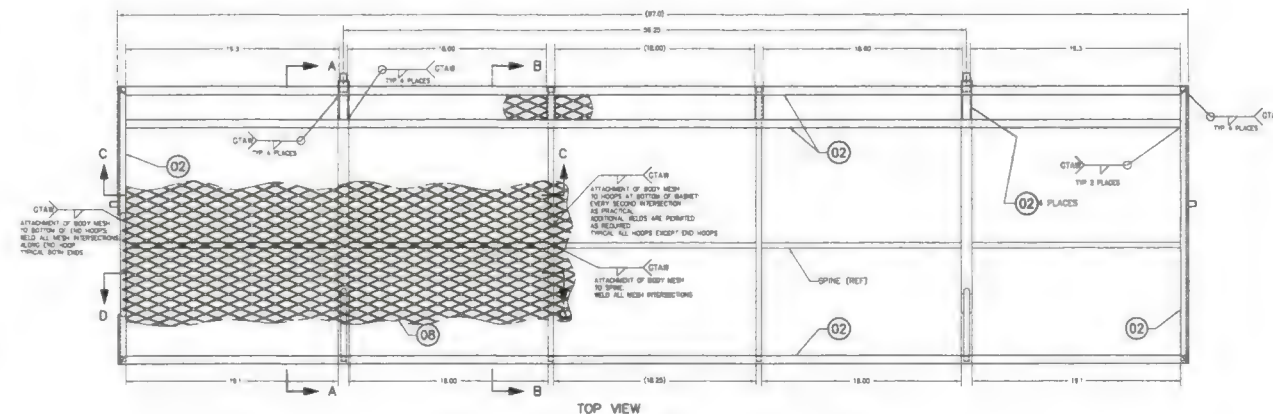
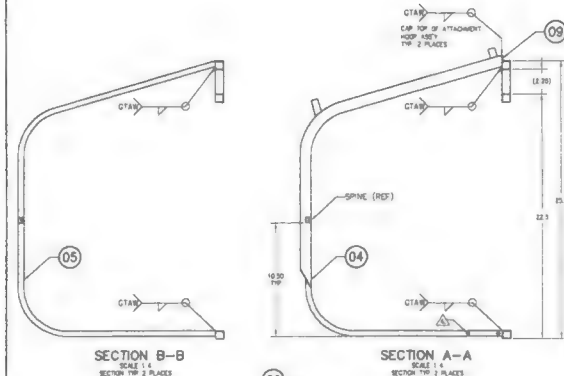
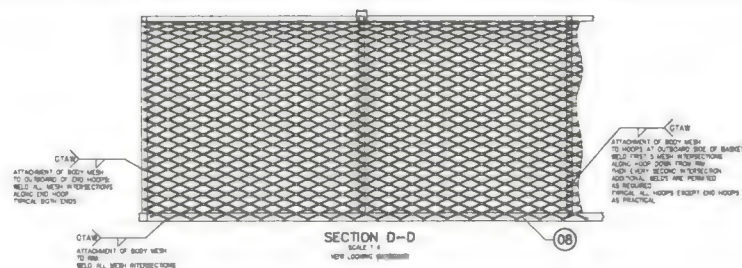


NOTE
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

[illegible]

BASIC CODE REF 345 332		DASH NO. 174 68 28 7-24-72 - 14-01-78 SEE 7-24-72 - 14-01-78		APPROVALS _____ DATE _____ GARY A. RATHBELL 30 OCT 1972		 AERO DESIGN LTD 1000A MAGUIRE BLVD PORTLAND, OREGON 97136	
C-COLLISION CHARGE OF WEIGHT		DASH NO. FOR LISTS		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON		EUROCORP ASS330 & ASS354 SERIES QUICK RELEASE CARGO BASKET BASKET ASSEMBLY (EXTRA LARGE)	
BASIC CODE REF 345 332		RETAIL NEW ITEM REF 345 332		DIMENSIONS X: 0.00 ± 0.010 Y: 0.00 ± 0.010 Z: 0.00 ± 0.010		ANGLES ± 1/2°	
REF 345 332 REF 345 332 REF 345 332		RETAIL NEW ITEM REF 345 332		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON		SCALE: 1" = 1" A0 94010 1	

REV	DESCRIPTION OF CHANGE	REFERENCE DRAWING	DATE	INITIALS
1	TITLE BLOCK UPDATED: WELDING ROD UPDATED: REFERENCE DOWNS ADDED		1/25/2010	
2	TITLE BLOCK UPDATED: WELDING ROD UPDATED: REFERENCE DOWNS ADDED		1/25/2010	

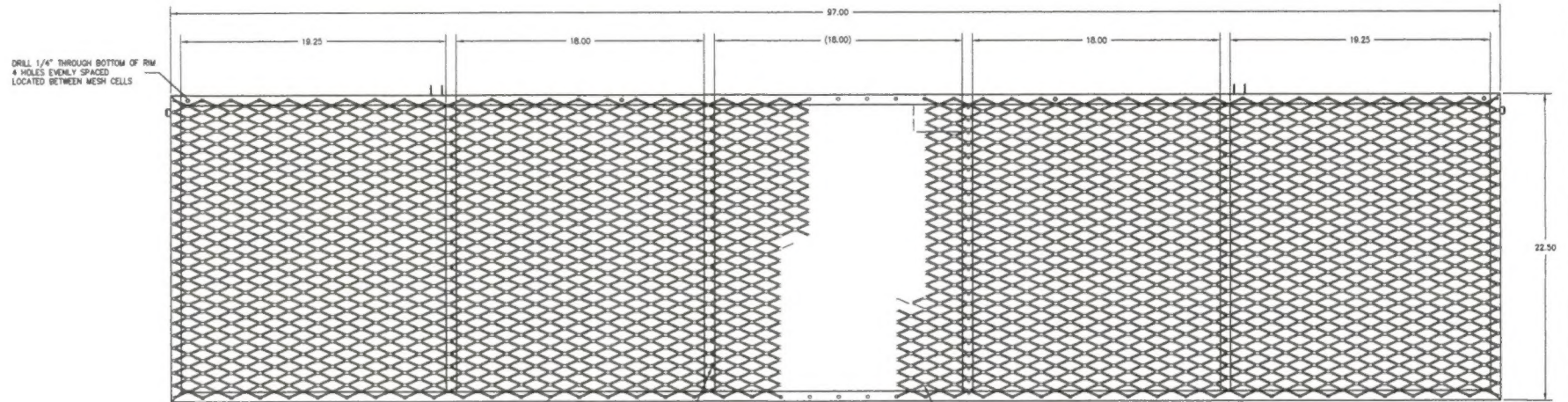


- NOTES:
- REMOVE ALL BURRS AND BREAK SHARP EDGES
 - PRIOR TO WELDING, DRILL 800 (0.125) HOLE IN ASSEMBLY FOR VENTING OF WELD GASES WHEN ASSEMBLY IS COMPLETE. FILL ALL EXPOSED HOLE WITH ROSETTE WELD
 - WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AND DYNAMIC
 - 4130 AND 4130 STEEL WELDING ROD SHALL CONFORM TO EN ISO 2 OR EQUIVALENT
 - STAPLER AND 4130 STEEL WELDING ROD SHALL CONFORM TO EN ISO 2 OR EQUIVALENT
 - WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AND DYNAMIC
 - DRIVING 84282 BEFORE WELDING HOOPS TO RIB
 - FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL SPEC	STOCK SIZE
1	08	CAP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	09	SPINE	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	01	BASKET BODY ASSEMBLY	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	02	HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	03	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	04	SPACER	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	05	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	06	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	07	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	08	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	09	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"
1	10	ATTACHMENT HOOP	4130 STEEL	4130 STEEL	1/2" X 1/2" X 1/2"

APPROVALS	DATE	SCALE	SIZE	TIME
DESIGNER: E. BURTON	20 AUG 11	1:4	1/2"	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES X 0.01 ± 0.010 1/2° X 0.1 ± 0.1 1/2° X 1.0 ± 0.1 1/2°				
AERO DESIGN LTD. POTTER, REVER, BC CANADA, V8A 0G3 EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY (EXTRA LARGE)				
SHEET 1 OF 1 A0 94011 1				

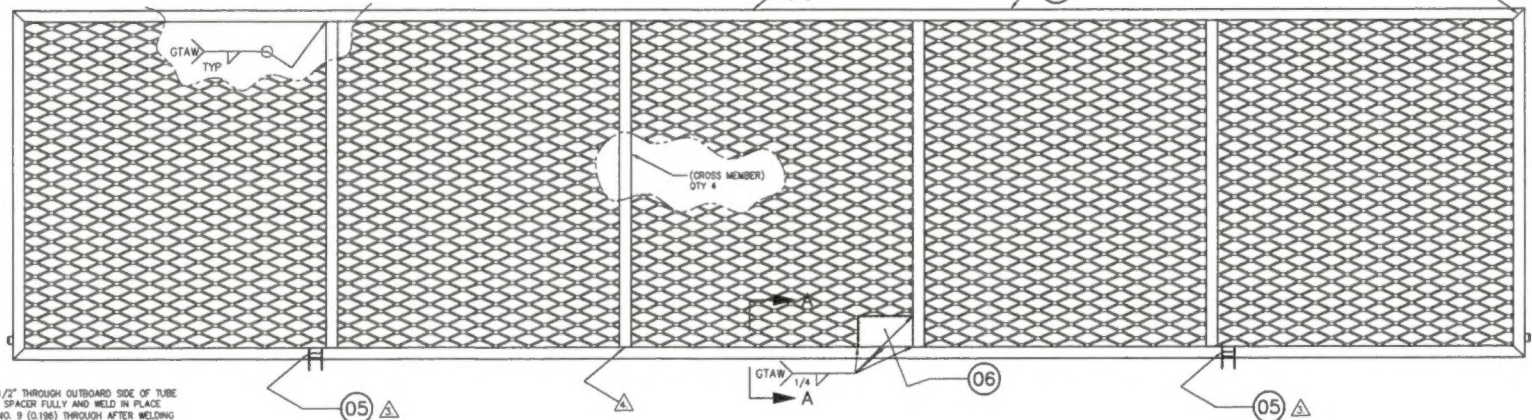
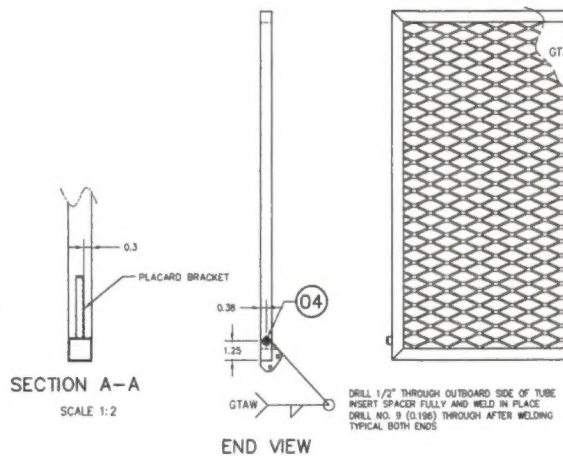
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISSEMINATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED: CHANGED 36273-01 TO 94263-01; ITEM #'S ADDED	BJC	16/07/2014
2	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



GTAW TYP
ATTACHMENT OF MESH TO RIM
WELD EACH INTERSECTION

GTAW TYP
ATTACHMENT OF MESH TO CROSS MEMBERS
WELD FIRST FIVE INTERSECTIONS
THEN EVERY SECOND INTERSECTION
ADDITIONAL WELDS ARE PERMITTED AS REQUIRED

BOTTOM VIEW (03) MESH



TOP VIEW

(01) LID ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
- 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
- DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES WHEN ASSEMBLY IS COMPLETE. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
- FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36254-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	ML-T-6736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			

LIST OF MATERIALS

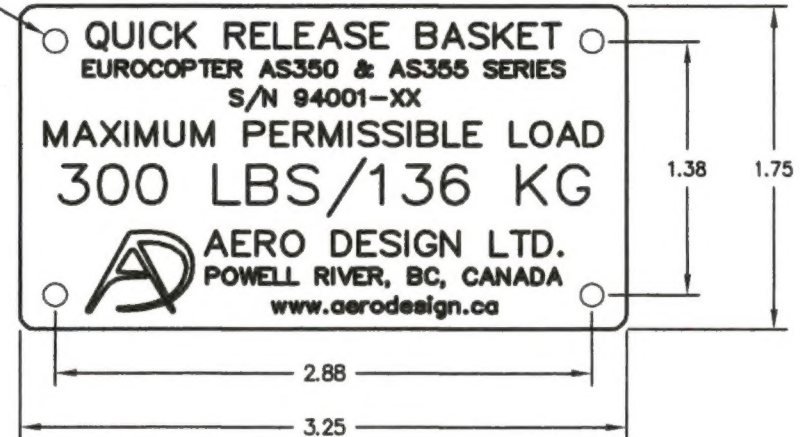
APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: R. RATHWELL	05 AUG 11		
CHECKED: E. BURGOIN		8808A MALASPONA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL: 604.480.5276 www.aerodesign.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY (EXTRA LARG)	
		DECIMALS ANGLES	
		X.XXX ±0.010 ±1/2"	
		X.XX ±0.03	
		X.X ±0.1	
SCALE 1:4		DWG SIZE	DWG NO.
SHEET 1 OF 1		A1	94012
		REV	1

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 94001-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS/136 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1					
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE A4	DWG. NO. 94027	REV. 1	



RED ASS50 DEI

WO# 2015-76

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

Aero Design

Parts Distribution Sheet

Description: Lid Prop

WO# _____

[illegible]